

Work Order ID 82166

Tuesday, March 27, 2012 3:42:10 PM

82166

Page 1

Item ID: D3793-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearshoe
Start Date: 3/23/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/30/2012 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: P Date: 20323 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3793	Rev A

100	FLOW WATER JET	0.00							
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100
Waterjet
FLOW CNC Waterjet
304 .040

Memo
1-Cut as per Dwg D3793
Dwg Rev: A
Prog Rev: A
2-Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
QC
Quality Control

Memo

120	QC8- Inspect parts - second check	0.00							
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120
QC
Quality Control

Memo

QC8- Inspect parts - second check

Sm / w 12 04 02 (16)

Sm / w 12 - 04 - 02 (16)

(16)

Scallop

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC	NC BRAKE	0.00				(14)			
Brake NC	Memo 1-Debur if necessary 2-Form on Brake as per Dwg D3793 using Jigs	0.00		SB 12/04/02					
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				(16)			
Quality Control	Memo	0.00		5, 12/04/03					
150 *150* Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				16			
Powder Coating	Memo START TIME: 9h20 OVEN TEMPERATURE: 320°F FINISH TIME: 9h50	0.00		m 117 338				(OP) 12/04/03	

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Revision ID: Stop ***NS2***
Item Name: Wearshoe
Start Date: 3/23/2012 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/30/2012 Req'd Qty: 12.00 ***12*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>FD-1</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

MLJ 12/04/03
12-04-3

Picklist Print

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Work Order ID: 82166

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Parent Item: D3793-3

D3793-3

Parent Item Name: Wearshoe

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No			100	sf	157.8867	1.2828	16.20379			
**										w/ 12 04 02			

M304S20GA

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	157.886744	
116623	0.2	
117933	27.3442	
118400	21.1723	
118964	36.5	
119346	29.8	
120604	42.870244	

DART AEROSPACE LTD		Work Order:	<i>82464</i>
Description: Wearshoe		Part Number:	D3793-3
Inspection Dwg: D3793	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.192	✓		VERN	HB-02
0.300 x 0.300	+/-0.010	0.306 x 0.308	✓		VERN	HB-02
1.885	+/-0.010	1.885	✓		VERN	HB-02.
4.389	+/-0.010	4.384	✓		VERN	HB-02
6.547	+/-0.010	6.541	✓		VERN	HB-02
6.00	+/-0.030	5.996	✓		VERN	HB-02.
6.75	+/-0.030	6.742	✓		VERN	HB-02.
2.000	+/-0.010	2.003	✓		VERN	HB-02.
4.750	+/-0.010	4.742	✓		VERN	HB-02
9.500	+/-0.010	9.493	✓		VERN	HB-02
14.250	+/-0.010	14.250	✓		MT	HB-01
17.750	+/-0.010	17.750	✓		MT	HB-01
26.735	+/-0.010	26.735	✓		MT	HB-01
Ø0.531 x 0.780	+0.008/-0.001	0.532 x 0.782	✓		VERN	HB-02.

Measured by: <i>Jm / mls</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: 04/02/12.	Date: 12/04/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD <i>[Signature]</i>	<i>[Signature]</i>

8

7

6

5

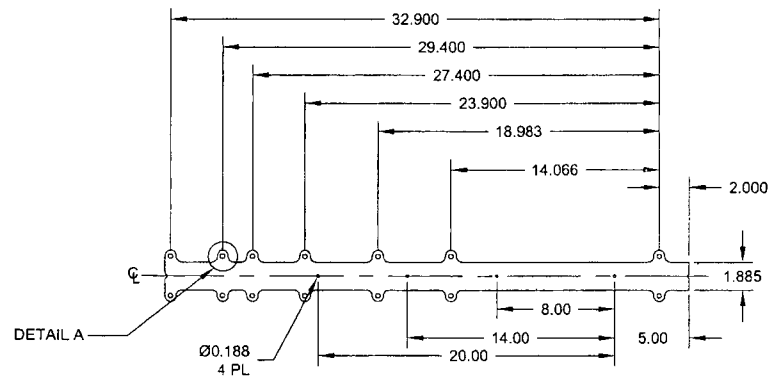
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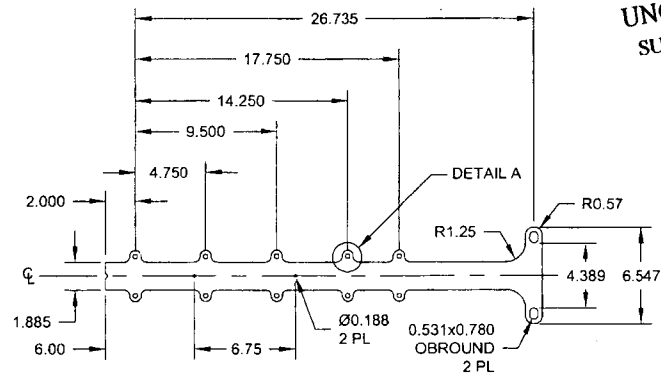
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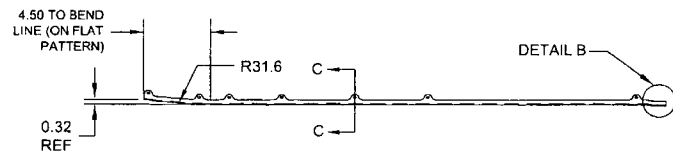
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82166



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08.05.14

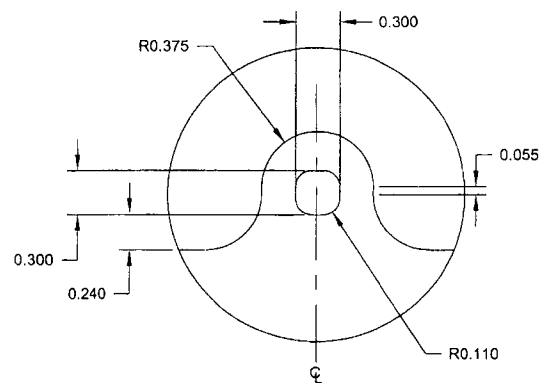
NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

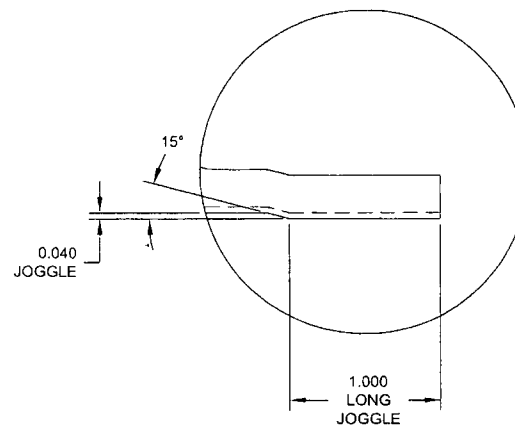
REV.	NEW ISSUE	DESCRIPTION	PH	08.05.14
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.14			

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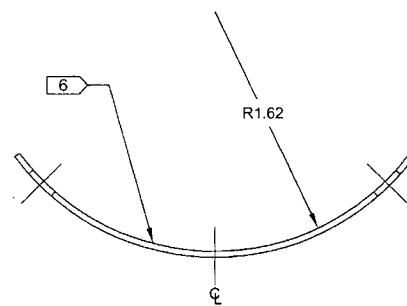
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

82166

RELEASED
08-05-23/10/14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	LS	DRAWING NO.	REV. A
MFG. APPR.	LS	D3793	SHEET 2 OF 2
APPROVED	LS	TITLE	SCALE
DE APPR.	LS	WEARSHOE	NTS
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8 7 6 5 4 3 2 1